

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003146**Date Inspected:** 06-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Chih-Ming/Zhao Chen Sun/ Chen X			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** OBG side, bottom, deck panels, floor beams a**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA observed ZPMC qualified welding personnel perform FCAW 3G welding on floor beam joint#SEG-018C following the guide lines of WPS# WPS-B-T-2233-B-U2-F. QC monitored the welding process continuously throughout the evening. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 24.8 – 25.9 Amps: 211 - 215 Travel speed: 109 - 114mm/min

Other general observations include ZPMC personnel fitting and welding OBG east fixture, OBG temporary support columns, grinding and weld bevel prep on various OBG components.

OBG bay 1

QA observed ZPMC personnel fitting u-rib stiffeners to deck plate. QA also noted that deck panels DP-383-001 and DP-412-001 on gantry 1 had been welded.

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OBG bay 2

QA observed ZPMC personnel installing bolts on 77 meter tower mock-up. QA noted that there was no other Caltrans work being performed in this bay on this day.

OBG bay 3

QA noted that there was no welding being performed in this bay on this day.

QA observed ZPMC personnel preparing parts for fit up and welding; (cutting parts, drilling and weld bevel prep).

QA observed ZPMC personnel fitting stiffeners to several side panels.

OBG bay 4

QA observed ZPMC qualified welding personnel FCAW butt joints on tower diaphragm internal flanges. QA observed ZPMC personnel preparing parts for fit up and welding; (cutting parts and weld bevel prep).

OBG bay 7

QA observed ZPMC personnel fit and SMAW tack welding stiffeners to several floor beam web plates.

QA observed ZPMC qualified welding personnel FCAW in the 3G position floor beam joint# SSD12-PP-040-134.

Other general observations include ZPMC personnel grinding and weld bevel prep on various OBG components.

OBG bay 8

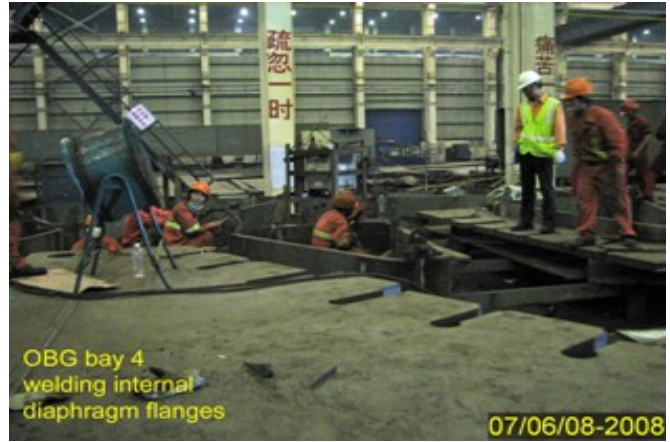
QA observed ZPMC personnel fit and SMAW tack welding longitudinal diaphragms.

No welding operations were observed in this bay today.

Other general observations include ZPMC personnel grinding and weld bevel prep on various OBG and tower components.

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Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
